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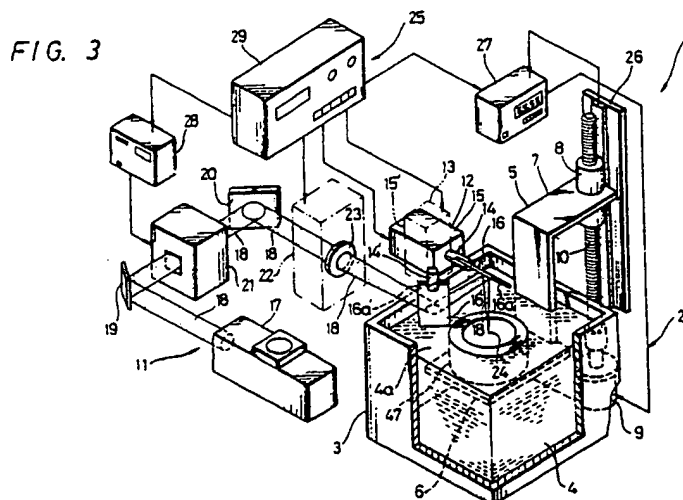
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(54) Method and apparatus for producing three-dimensional objects.

(57) A method of and apparatus for producing a three-dimensional object are provided, in which a beam from beam oscillating means is irradiated on a liquid surface of a liquid photo-curable resin to form a cured resin layer having a pattern corresponding to a shape of an exploded plane which results from exploding a desired three-dimensional object image by a certain direction, a liquid photo-curable resin is placed on the cured resin layer and a beam is again irradiated on a liquid surface of the liquid photo-

curable resin layer thereby to sequentially laminated a cured resin layer onto the already-cured resin layer, so as to form a desired three-dimensional object. The method and apparatus are characterised by the use of configuration scanning in which a configuration line of the exploded plane is scanned by the beam irradiation based on a vector-scanning system and field scanning in which a whole surface of the exploded plane is scanned according to a raster-scanning system.



METHOD AND APPARATUS FOR PRODUCING THREE-DIMENSIONAL OBJECTS

The present invention relates generally to a method of and apparatus for producing a three-dimensional object in which an exposure beam is irradiated on a liquid photo-curable resin to produce a three-dimensional object on the basis of a desired three-dimensional object image. More particularly, this invention relates to a method of and apparatus for producing a three-dimensional object in which a liquid surface of a liquid photo-curable resin is exposed in response to the shapes of planes exploded from a certain direction of a three-dimensional object image thereby to form a cured resin layer and in which the cured resin layer is sequentially laminated, to build up the three-dimensional object. Furthermore, the present invention relates to a method of and apparatus for producing a three-dimensional object in which the scanning of the beam on the liquid surface of the liquid photo-curable resin is performed by switching two kinds of the scanning systems thereby to produce a three-dimensional object whose surface is smooth, and in which a three-dimensional object can be produced at high speed.

In the prior art, it is proposed to produce a product of a desired shape by irradiating a liquid photo-curable resin with a predetermined exposure beam. For example, US patent no 4041476 and Japanese patent application no 63-267945 describe such previously-proposed method.

Figure 1 of the accompanying drawings shows an example of a three-dimensional object producing apparatus a which embodies the above described method.

It will be seen in figure 1 that a resin storage tank b holds a liquid photo-curable resin c which is cured by the radiation of a predetermined exposure beam, for example, ultra-violet (UV) rays. An elevator d is provided with a horizontal, plate-shaped stage e, and this elevator d is moved up and down by some suitable moving means (not shown). A beam scanner f is located above the resin storage tank b and allows an exposure beam g to be converged on a liquid surface h of the liquid photo-curable resin c. A shape-forming controller i is provided, and the scanning of the exposure beam g is performed on the liquid surface h by the beam scanner f under the control of the controller i and the movement of the elevator d is also performed under the control of the controller i.

When forming a predetermined three-dimensional object, at first, the elevator d is moved to the initial position, as shown by the solid line in figure 1, such that a layer of the liquid photo-curable resin c of a predetermined thickness (this thickness will be described more fully later) is located on the

stage e of the elevator d.

The scanning of the exposure beam g in the liquid surface h is performed next. In this scanning process, raster scanning is performed with patterns corresponding to planes in which a desired three-dimensional object image j is exploded into a number of planes in a certain direction thereof. In the following description, the respective planes will be referred to as exploded planes.

When the scanning of beam g is carried out, the portion of the liquid photo-curable resin c which is irradiated with the beam g is cured to produce one sheet-shaped cured-resin layer having a configuration corresponding to that of the exploded plane of the liquid surface h. The elevator d is incrementally moved downwards at a pitch corresponding to the exploded pitch in which the three-dimensional object image j is exploded into a number of exploded planes in a certain direction, and at each increment a sheet-shaped cured-resin layer is completely formed. The thickness of the liquid photo-curable resin c on the stage e in the initial state is selected to be equal to the above described pitch. Accordingly, the liquid photo-curable resin of the thickness corresponding to one pitch amount flows to the upper surface of the cured-resin layer, and the scanning of beam is performed on the next exploded plane to thereby form other cured-resin layer. At that time, the above described cured-resin layer is bonded to the previously formed cured-resin layer. In this manner, a new cured-resin layer k is sequentially laminated onto the cured-resin layer already formed, and a desired three-dimensional object is formed by a number of laminated cured-resin layers.

According to the method of producing a three-dimensional object as described above, the three-dimensional object can be produced on the basis of the desired three-dimensional object image so that, as compared with a prior-art method for producing a three-dimensional object by utilising a metal mould, a three-dimensional object can be readily produced as an experiment. Therefore, development from the design stage to the mass-production stage can be readily carried out at low cost, without moulds needing to be produced for intermediate designs.

In the above mentioned three dimensional object producing method, if the exposure beam is raster-scanned system, there arises the problem that the surface of the three-dimensional object formed has irregularities imported to it.

Figure 2 is a plan view conceptually illustrating part of the locus in which the scanning of exposure beam is performed on a certain exploded plane. In

figure 2, reference letters, k, k, ... designate main scanning lines of the exposure beam g, ie, lines along which beam spots t, t, ... are moved and reference letter m represents the configuration line of the corresponding exploded plane.

As is clear from figure 2, of the outer confirmation of the cured-resin layer formed, on the portion extended in the direction perpendicular to the main scanning direction of the beam there appears one portion of each of the shapes of the end beam spots t, t, ... of the beam main scanning lines k, k, ..., which presents the irregular (ie, concaved and convexed) configuration line on the above portion. Consequently, the surface of the three-dimensional object image formed by the collection of irregular configuration lines are caused to have very small concavities and convexities.

A known alternative to raster-scanning is vector scanning. In vector scanning, a straight line-shaped main scanning direction is not provided uniquely but instead scanning proceeds with the scanning direction being a direction defined by vector data. This vector scanning system is frequently utilised, for example, by a picture drawing system which employs a polygon mirror and a moveable picture drawing table or a picture drawing system which employs a so-called X-Y photo plotter.

Accordingly, if the scanning of the exposure beam g in this kind of the three-dimensional object producing method is performed according to the vector scanning system, then the configuration of the exploded plane can be drawn by lines formed of continuous beam spots moving in accordance with the extended direction of the configuration lines, ie, lines having a directivity in the two-dimension. Therefore, it is possible to obtain a three-dimensional object whose surface is smooth.

However, in this method of producing a three-dimensional object, if the scanning of the exposure beam is carried out according to the vector scanning system, the vector-scan has directivity in the two-dimension so that, so long as the configuration line of the exploded plane is not a straight line, the directions of the beam spots must successively be changed to many directions, which takes much longer than scanning a plane of the same area as compared with the above described raster scanning system.

Therefore, it is a general object of the present invention to provide an improved method of and apparatus for producing a three-dimensional object in which the above described defects encountered with the prior art can be eliminated.

According to a first aspect of the present invention, there is provided a method of producing a three-dimensional object in which a beam is irradiated on a liquid surface of a liquid photo-curable resin to form a cured resin layer having a pattern

corresponding to a shape of an exploded plane which results from exploding a three-dimensional object image in one direction, a liquid photo-curable resin is placed on said cured resin layer and a beam is again irradiated on a liquid surface of the liquid photo-curable resin layer to thereby to sequentially laminate a cured resin layer onto the already-cured resin layer, so as to form a desired three-dimensional object, said method comprising the steps of:

(a) carrying out configuration scanning in which a configuration line of said exploded plane is scanned by said beam irradiation based on a vector-scanning system; and

(b) carrying out field scanning in which a whole surface of said exploded plane is scanned according to a raster-scanning system.

According to a second aspect of the invention, there is provided an apparatus for producing a three-dimensional object in which a beam is irradiated on a liquid surface of a liquid photo-curable resin to form a cured resin layer having a pattern corresponding to a shape of an exploded plane which results from exploding a three-dimensional object image in one direction, a liquid photo-curable resin is placed on said cured resin layer and a beam is again irradiated on a liquid surface of the liquid photo-curable resin layer thereby to sequentially laminate a cured resin layer onto the already-cured resin layer, so as to form a desired three-dimensional object, said apparatus comprising:

(1) means for performing configuration scanning in which a configuration line of said exploded plane is scanned by said beam irradiation based on a vector-scanning system; and

(2) beam scanning means for performing field scanning in which a whole surface of said exploded plane is scanned according to a raster-scanning system.

The invention will be further described by way of non-limitative example with reference to the accompanying drawings, in which:-

Figure 1 is a diagrammatic view of a section of an example of an apparatus which embodies a prior art method for producing a three-dimensional object;

Figure 2 is a schematic plan view to which reference will be made in explaining defects inherent in the prior-art method for producing a three-dimensional object;

Figures 3 to 5 are diagrams showing an example of an apparatus which embodies a method for producing a three-dimensional object according to the present invention wherein:

Figure 3 is a perspective view of the three-dimensional object producing apparatus and illustrating the same in a partly cut-away fashion;

Figure 4 is a fragmentary, cut-away front

view showing a work section of the apparatus;

Figure 5 is a block diagram showing a circuit of a control section of the apparatus;

Figures 6A. to 6D are perspective views showing the processes for producing a three-dimensional object in that order, respectively;

Figures 7A to 7D are diagrammatic views of section showing the processes for producing a three-dimensional object in that order, respectively;

Figure 8 is a conceptual diagram partly showing the thus formed three-dimensional object in the separated form of each cured-resin layer; and

Figure 9 is a timing chart to which reference will be made in explaining a switching operation of beam scanning systems:

The present invention will hereinafter be described in detail with reference to the drawings, in which like reference numerals are used to identify the same or similar parts in the several views.

A description of an example of an apparatus which embodies the present invention will be given, followed by a description of the method of its use.

Referring to figures 3 to 5, there is provided a three-dimensional object producing apparatus which is depicted by reference numeral 1. The three-dimensional object producing apparatus 1 is comprised of a work section having a resin storage tank containing a liquid photo-curable resin, an elevator and the like, a beam scanning section for causing an exposure beam to scan a liquid surface of the liquid photo-curable resin and a control section for controlling the operations of the work section and the beam scanning section.

As shown in figures 3 and 4, there is provided a work section 2 which provides a resin storage tank 3 to store therein a liquid photo-curable resin 4.

The liquid photo-curable resin 4 is presented in the form of liquid which can be cured by the irradiation of a predetermined exposure beam. Further, the liquid photo-curable resin 4 is required to have a bonding property so that, when cured on the surface of the already-cured portion, it sticks to the above mentioned surface. Also, it is preferable that the viscosity of this liquid photo-curable resin 4 is as low as possible. As the liquid photo-curable resin 4, it is possible to use, for example, a UV-curable denatured acrylate.

In figures 3 and 4, reference numeral 5 designates an elevator (appearing also in figures 6 and 7) which is comprised of a horizontal, plate-shaped stage 6 located at the lower end thereof. Further, in the elevator 5, a nut 8 is secured to an upper end 7 thereof and the nut 8 is engaged with a feed screw 10 rotated by a stepping motor 9 so that, when the feed screw 10 is rotated by the stepping motor 9, the nut 8 is moved along the feed screw 10 in its

axial direction, whereby the elevator 5 may be moved up and down by operation of the stepper motor.

The above mentioned elevator 5 is located such that the stage 6 thereof is kept in the liquid photo-curable resin 4 stored in the resin storage tank 3. The elevator 5 is also moveable step by step at a predetermined pitch.

A beam scanning section, generally designated by reference numeral 11 in figures 3 and 4, will be described with reference to figures 3 and 4.

Referring to figures 3 and 4, the beam scanning section 11 includes a galvano scanner 12 which controllably deflects an exposure laser beam, emitted from a laser beam oscillator which will be explained later, in the left and right direction in figure 4 (this direction will hereinafter be referred to as the "first scanning direction") relative to a liquid surface 4a of the liquid photo-curable resin 4. Further, the beam scanning section 11 includes another galvano scanner 13 which deflects the exposure beam in the direction (this direction will hereinafter be referred to as "second scanning direction") perpendicular to the first scanning direction. These galvano scanners 12 and 13 are comprised of drive sections 15, 15' having rotary shafts 14, 14' rotatable around their axes at high speed and galvano mirrors 16, 16' secured to the rotary shafts 14, 14'.

In one of these two galvano scanners 12 and 13, ie, the galvano scanner 12 (this galvano scanner 12 will hereinafter be referred to as a "first galvano scanner"), the axial direction of the rotary shaft 14 thereof extends in the direction parallel to the second scanning direction, and also the galvano mirror 16 thereof is located substantially right over the stage 6 of the elevator 5. In the other galvano scanner 13 (this galvano scanner 13 will hereinafter be referred to as a "second galvano scanner"), the axial direction of the rotary shaft 14' thereof extends along the up and down direction, and a reflection surface 16a of the galvano mirror 16' thereof is faced to the reflection surface 16a of the galvano mirror 16 of the first galvano scanner 12 in the lateral direction.

Referring to figures 3 and 4, there is provided a laser beam oscillator 17 which emits a predetermined exposure laser beam 18, for example, an argon ion laser beam having a wavelength of, for example, 360 nanometers or a helium cadmium laser beam having a wavelength of 325 nanometers, which is suitable to cure the photo-curable resin. The laser beam 18 emitted from the laser beam oscillator 17 is totally reflected in sequence in a predetermined direction by total reflection mirrors 19 and 20 so that it may become incident upon the galvano mirror 16' of the second galvano scanner 13. An acoustooptic (A/O) modulator 21 is

provided between the two total reflection mirrors 19 and 20, and a focus controller 22 having a focusing lens 23 is provided between the total reflection mirror 20 and the second galvano scanner 13.

Accordingly, the exposure laser beam 18 emitted from the laser beam oscillator 17 is totally reflected toward the acoustooptic modulator 21 by the total reflection mirror 19 and is controlled to travel through a predetermined light path thereafter by the ON-OFF control of a switching operation in the acoustooptic modulator 21. Thus, when the switching operation of the acoustooptic modulator 21 is in its ON state, the exposure laser beam 18 becomes incident upon the total reflection mirror 20 and is then reflected toward the focusing lens 23 of the focus controller 22. When the exposure laser beam 18 passes the focusing lens 23, the light bundle thereof is focused or converged and sequentially reflected by the two galvano mirrors 16' and 16, whereby the exposure laser beam 18 is directed onto the liquid photo-curable resin 4 from above. The exposure laser beam 18 is focused into the light bundle by the focusing lens 23 so that it is always focused onto the liquid surface 4a of the liquid photo-curable resin 4 as a beam spot 24 of a predetermined beam diameter. Further, when the rotary shaft 14 of the first galvano scanner 12 is rotated to swing the galvano mirror 16, the exposure laser beam 18 scans the liquid surface 4a of the liquid photo-curable resin 4 in the first scanning direction. Whereas, when the rotary shaft 14' of the second galvano mirror 13 is rotated to swing the galvano mirror 16', the exposure laser beam 18 scans the liquid surface 4a of the liquid photo-curable resin 4 in the second scanning direction.

Therefore, each time the line scanning (this line scanning will hereinafter be referred to as "first line scanning") by the exposure laser beam 18 in the first scanning direction done only by swinging the first galvano mirror 16 is ended, the exposure laser beam 18 is irradiated while changing the position in the second scanning direction of the first line scanning by swinging the second galvano mirror 16'. Alternatively, each time a line scanning (this line scanning will hereinafter be referred to as "second line scanning") by the exposure laser beam 18 in the second scanning direction done only by swinging the second galvano mirror 16' is ended, the exposure laser beam 18 is irradiated while changing the position in the first scanning direction of the second line scanning by swinging the first galvano mirror 16, thereby the irradiation of laser beams being performed according to the raster-scanning system. Further, when the first galvano mirror 16 and the second galvano mirror 16' are both swung simultaneously, the irradiation of the laser beams is performed according to the vector scanning system in which the scanning of the exposure laser beam

18 is performed with directivity in the two dimensions.

As shown in figure 3 to 5, there is provided a control section 25. An elevator position detecting sensor 26 is located in parallel to the above described feed screw 10 so as to detect the position of the elevator 5. An elevator controller 27 is supplied with a signal indicative of the position of the elevator 5 from the sensor 26 and controls the revolution of the stepping motor 9 in accordance with this signal, thereby the position of the elevator 5 being controlled.

An acoustooptic modulator controller 28 controls the switching operation of the acoustooptic modulator 21. A galvano controller 29 controls the operations of acoustooptic modulator 28, the galvano scanners 12, 13 and the focus controller 22 by the commands thereof.

A circuit, generally designated by reference numeral 30 in figure 5, is provided in association with the above described control section 25.

Referring to figure 5, a memory 31 is connected to a three dimensional object programming apparatus (not shown) such as a so-called computer-aided design (CAD) system or the like. The memory 31 is supplied with pixel signals exploded by the X and Y directions of the exploded plane of a certain or desired three-dimensional object image designed by the three-dimensional object programming apparatus and temporarily stores these pixel signals.

A modulator circuit 32 is connected to the memory 31 and modulates the pixel signals of the exploded plane temporarily stored in the memory 31 into coordinate signals indicating a raster, ie, the position whereat the exposure laser beam 18 scans the scanning region of the liquid surface 4a of the liquid photo-curable resin 4. A beam position control circuit 33 includes the memory 31 and the modulator circuit 32.

Digital-to-analog (D/A) converter circuits 34a and 34b are connected to the modulator circuit 32, and gate circuits 35a and 35b are respectively connected at their inputs to the D/A converters 34a and 34b and are also connected at their outputs to the first and second galvano scanners 12 and 13. Of the coordinate signals modulated by the modulator circuit 32, the signal in the X direction, ie, the signal in the first scanning direction is converted to an analog signal by the D/A converter circuit 34a and is supplied through the gate circuit 35a to the drive section 15 of the first galvano scanner 12. On the other hand, the coordinate signal in the Y direction, ie, the second scanning direction is converted to an analog signal by the D/A converter circuit 34b and is then supplied through the gate circuit 35b to the drive section 15' of the second galvano scanner 13. The drive sec-

tions 15 and 15' swing the galvano mirrors 16 and 16' during the period in which they are supplied with the input signals, respectively.

A scanning system change-over circuit 36 is connected to the gate circuits 35a, 35b and the modulator circuit 32. This scanning system change-over circuit 36 is adapted to change-over the scanning system of the beam spot 24 of the exposure laser beam 18 either to the raster-scanning system or to the vector-scanning system. In a case of the raster-scanning system, the scanning system change-over circuit 36 changes-over the main scanning direction, ie, the line scanning direction either to the raster-scanning (this will hereinafter be referred to as "first raster scanning") provided as the first scanning direction or to the raster-scanning (this will hereinafter be referred to as "second raster scanning") provided as the second scanning direction. Accordingly, the scanning system is alternately changed-over to the vector-scanning system or the raster-scanning system. Further, the raster-scanning system is changed-over to the first or second raster scanning system.

The irradiation of exposure laser beam 18 according to the vector-scanning system is carried out only on the pixel signal of a configuration line of the corresponding exploded plane. Consequently, in that case, of the pixel signals inputted to the memory 31, only data forming the configuration line is supplied to the modulator circuit 32.

Therefore, the gate circuits 35a and 35b are opened and/or closed by the command signal issued from the scanning system change-over circuit 36. When the scanning system is the vector-scanning system, the two gate circuits 35a and/or 35b are opened at any time. On the other hand, when the scanning system is the first raster scanning system, the gate circuit 35b is momentarily opened each time the scanning of one scanning line in the first scanning direction is completed, thereby slightly rotating the galvano mirror 16' of the second galvano scanner 13 so that the line position of the line scanning of the exposure laser beam 18 is moved to the adjacent line in the second scanning direction. Further, when the scanning system is the second raster scanning system, the gate circuit 35a is momentarily opened each time the scanning of one scanning line in the second scanning direction is completed, thereby slightly rotating the galvano mirror 16 of the first galvano scanner 12 so that the line position of the line scanning of the exposure laser beam 18 is moved to the adjacent line in the first scanning direction.

An acoustooptic modulator drive circuit 37 is connected to the beam position control circuit 33 and supplies the acoustooptic modulator 21 with a control signal corresponding to the existence or non-existence of the signal on one line in the X

direction or on one line in the Y direction of plane data. Accordingly, the light path in which the exposure laser beam 18 emitted from the laser beam oscillator 17 travels from the acoustooptic modulator 21 is turned ON and/or OFF under the control of the acoustooptic modulator drive circuit 37.

A focus control circuit 38 is provided to control the position of the focusing lens 23 in the focusing direction such that the exposure laser beam 18 may always be focused on the liquid surface 4a of the liquid photo-curable resin 4 as a beam spot of a predetermined beam diameter.

A motor drive circuit 39 generates a command signal to drive the aforementioned stepping motor 9 on the basis of the signal from the beam position control circuit 33. When the operation in which the three-dimensional object is produced is started, the elevator 5 is moved such that the stage 6 thereof is located at the position lower than the liquid surface 4a of the liquid photo-curable resin 4 by a pitch of one layer, ie, at the position lower than the liquid surface 4a by a pitch of an exploded plane when the three-dimensional object image is exploded into a plurality of exploded planes. The above described position will hereinafter be referred to as the "initial position". Further, after the above described producing operation of the three-dimensional object is started, the elevator 5 is moved downwards by the pitch of one layer each time the beam scanning on one exploded plane is finished.

The above described layer pitch is determined to be less than one half of the thickness of the cured layer provided when the liquid photo-curable resin 4 is cured by the irradiation of the exposure laser beam 18. For example, when the exposure laser beam 18 is irradiated on the liquid surface 4a of the liquid photo-curable resin 4 so that the liquid photo-curable resin 4 is cured to have a thickness of about 0.56 to 0.7 mm from the liquid surface 4a thereof, the layer pitch is selected to fall in a range of from about 0.2 to 0.3 mm.

The three-dimensional object is produced by utilising the above described three-dimensional object producing apparatus 1 as follows.

In this case, the designed three-dimensional object image 47 (see figure 3) is a thick cylinder in shape.

When the three-dimensional image producing operation is started, the elevator 5 is moved to the initial position and the liquid photo-curable resin 4 having the thickness of one layer pitch is located on the top surface of the stage 6 of the elevator 5.

Under this condition, the exposure laser beam 18 scans the liquid surface 4a of the liquid photo-curable resin 4 at its region corresponding to the stage 6. The scanning of the exposure laser beam 18 is performed on the whole region or one portion of each exploded plane of the corresponding three-

dimensional object. Also, the scanning is sequentially performed from either one of two exploded planes at the respective ends in the exploded direction of a number of exploded planes. Further, the scanning on one exploded plane is performed either by the vector-scanning system (this will hereinafter be referred to as "configuration scanning") with a pattern corresponding to the configuration line of the corresponding exploded plane or by the raster-scanning system (this will hereinafter be referred to as "field or plane scanning") with a pattern corresponding to the whole region of the corresponding exploded plane. Simultaneously, the configuration scanning and the field scanning are alternately changed-over and performed at every layer. Also, the field scanning is performed such that the first raster scanning and the second raster scanning are alternately changed-over.

Figure 9 is a timing chart to which reference will be made in explaining the switching operation of the scanning systems.

From the condition that the elevator 5 is moved to the initial position, the configuration scanning is performed on the first exploded plane, whereby the scanning of the exposure laser beam 18 is performed with a pattern corresponding to the configuration line of the first exploded plane, ie, a pattern corresponding to the outer peripheral line and the inner peripheral line according to the vector-scanning system. Therefore, as shown in figure 6A and figure 7A, an annular cured stripe 41₁ defining the outer periphery of the first exploded plane and an annular cured stripe 42₁ for defining the inner periphery of the first exploded plane are formed on the stage 6 of the elevator 5, whereas the liquid photo-curable resin 4 existing between the cured stripes 41₁ and 42₁ is not cured and left as it is.

When the configuration scanning is finished, the elevator 5 is moved downwards by one layer pitch, whereby the liquid photo-curable resin 4 having a thickness of one layer pitch is flowed onto the cured stripes 41₁ and 42₁ and the non-cured portion.

Under this condition, the field scanning of the exposure laser beam 18 is performed on the second exploded plane according to the first raster scanning system. In the first raster scanning system, the line scanning is performed by swinging the galvano mirror 16 of the first galvano scanner 12. Each time one line scanning is ended, the galvano mirror 16' of the second galvano scanner 13 is rotated by an angle equivalent to one line pitch, thereby the position of the line scanning being sequentially moved towards the second scanning direction so that the irradiation of the exposure laser beam 18 is performed so as to define the exploded plane from a plane standpoint. At that time, the region in which the liquid photo-

curable resin 4 is not yet cured because the irradiation of the exposure laser beam 18 is not performed on the first exploded plane, ie, the liquid photo-curable resin 4 existing in the region between the annular cured stripes 41₁ and 42₁ is also cured by the irradiation of the exposure laser beam 18 with the result that the liquid photo-curable resin 4 is simultaneously cured. Therefore, as shown in figures 6B and 7B, a substantially sheet-shaped cured resin layer 43₁ having a thickness corresponding to a pitch of two layers is produced.

When the above described cured resin layer 43₁ is formed, the annular cured stripes 41₁ and 42₁ are bonded to the cured resin layer 43₁, thereby producing a composite cured resin layer 44₁ having substantially the same shape as those of the first and second exploded planes.

In figures 6 and 7, reference numerals 45, 45 ... or 46, 46 ... designate bar-shaped cured portions formed by one line scanning (in figure 8, one portion of the cured portions 45, 45 or 46, 46 is shown in the respective cured resin layers 43, 43 ... by lines).

When the elevator 5 is moved downwards by one layer pitch, the liquid photo-curable resin 4 of amount corresponding to the thickness of one layer pitch is flowed onto the cured resin layer 43₁, and the irradiation of the exposure laser beam 18 is performed on the third exploded plane. This irradiation of the laser beam 18 is performed only on the configuration line of the third exploded plane according to the configuration scanning system. Therefore, as shown in figures 6C and 7C, two annular cured stripes 41₂ and 42₂ are formed on the already formed cured resin layer 43₁, the cured stripes 41₂ and 42₂ are bonded to the composite cured resin layer 44₁ and are unitarily formed therewith.

From this state, the elevator 5 is moved downwards by one layer pitch, and the irradiation of the exposure laser beam 18 is performed on a fourth exploded plane according to the field scanning base on the second raster-scanning system. In the second raster-scanning system, the line scanning is performed by swinging the second galvano mirror 16'. Each time one line scanning is completed, the first galvano mirror 16 is rotated by the angle equivalent to one line pitch, thereby the position of the line scanning being sequentially moved towards the first scanning direction so that the irradiation of the exposure laser beam 18 is carried out so as to define the fourth exploded plane from a plane standpoint. At that time, the region in which the liquid photo-curable resin 4 is not cured since the irradiation of the exposure laser beam 18 is not performed on the third exploded plane, ie, the region between the cured stripes 41₂ and 42₂ is simultaneously cured. Therefore, as

shown in figures 6D and 7D, a cured resin layer 43₂ having a thickness corresponding to the pitch of two layers is formed. The cured stripes 41₂ and 42₂ are bonded to and unitarily formed with the cured resin layer 43₂ when the cured resin layer 43₂ is formed, thereby a composite cured resin layer 44₂ having substantially the same shape as those of the third and fourth exploded planes being formed.

The above described operation is repeatedly carried out, whereby a number of cured resin layers 43₁, 43₂, ..., 43_n are laminated on the stage 6 while leaving the cured stripes 41₁, 42₁, 41₂, 42₂, 41_n and 42_n thereamong, thereby forming a three-dimensional object 47 having the same shape of the three dimensional object image 46.

Therefore, the surface of the thus formed three-dimensional object 47 can be made very smooth. In other words, the other peripheral surface and the inner peripheral surface of the three-dimensional object 47 are formed of outer side surfaces of the cured stripes formed by the vector-scanning at the pitch of one layer so that, when seen on the whole, the surface of the three-dimensional object 47 can be made very smooth without irregularities at all.

In this embodiment, the line scanning direction of the raster-scanning system done by the pitch of one layer is alternately changed so that, when the cured stripes 45, 45, ... and 46, 46 are cured, the directions in which the cured stripes 45, 45, ... and 46, 46 ... are warped due to the contraction are not regular, thereby a three-dimensional object have no distortion being obtained.

Further, since the line scanning direction is changed at every other cured resin layer, the starting point and the ending point of the line scanning can be prevented from reaching any side surface of the three-dimensional object, thus making it possible to obtain a three-dimensional object all of whose side surfaces are smooth.

As is clear from the foregoing description, according to the method of producing a three-dimensional object of the present invention, the irradiation of beam is performed on the liquid surface of the liquid photo-curable resin to thereby from the cured resin layer having a pattern corresponding to the shape of the exploded plane which results from exploding the three-dimensional object image by one direction. In the next process, the liquid photo-curable resin is paced on the cured resin layer and the irradiation of beam is again performed on the liquid surface of the liquid photo-curable resin, thereby laminating the cured resin layers. Thus, the cured resin layer is sequentially laminated to form a desired three-dimensional object. Salient features of the above described arrangement are as follows:-

The above described irradiation of beam is performed by the beam scanning section which is composed of beam oscillating means, acoustooptic modulating means, the first galvano mirror for deflecting the beam in one straight line direction on the exploded plane and the second galvano mirror for deflecting the beam in the direction perpendicular to the above mentioned straight line. Further, the irradiation of beam is performed by two kinds of scanning systems, ie, the configuration scanning system in which the configuration line of the exploded plane is scanned by the vector-scanning system and the field-scanning system in which the whole surface of the exploded plane is scanned by the raster-scanning system. The configuration scanning is carried out each time the cured resin layer is formed by one or a plurality of field-scanning operations.

Therefore, of the laminated cured resin layers, the layer with its outward form being cured is formed on every other one or several cured resin layers by the configuration scanning based on the vector-scanning system, whereby the outward form of that cured resin layer can be made smooth. Thus, when the thus formed three-dimensional object is seen on the whole, the surface of the three-dimensional object can be made very smooth.

Further, since the beam switching control operation necessary for the beam scanning is performed by the acoustooptic modulating means whose control operation is performed at an electrical speed, the switching between the vector-scanning and the raster-scanning can be made at high speed and the scanning of beam can also be made at high speed, whereby the three-dimensional object can be produced at high speed.

While the configuration scanning is performed at every other cured resin layer in the above described embodiment, it is also possible for the configuration scanning to be performed at every 2 or more cured resin layers formed by the field scanning.

The method for producing a three-dimensional object of the present invention is not limited to the apparatus which is constructed as in the above mentioned embodiment. The apparatus described in the above mentioned embodiment is described herein as an example of apparatus which can embody the method of the present invention.

Furthermore, it is needless to say that the kinds of the liquid photo-curable resin, the kinds of the exposure beam and the shape of the three-dimensional object are not limited to those of the aforementioned embodiment.

Having described a preferred embodiment of the invention with reference to the accompanying drawings, it is to be understood that the invention is not limited to that precise embodiment and that

various changes and modifications could be effected by one skilled in the art without departing from the scope of the invention as defined in the appended claims.

Claims

1. A method of producing a three-dimensional object in which a beam is irradiated on a liquid surface of a liquid photo-curable resin to form a cured resin layer having a pattern corresponding to a shape of an exploded plane which results from exploding a three-dimensional object image in one direction, a liquid photo-curable resin is placed on said cured resin layer and a beam is again irradiated on a liquid surface of the liquid photo-curable resin layer to thereby to sequentially laminate a cured resin layer onto the already-cured resin layer, so as to form a desired three-dimensional object, said method comprising the steps of:

(a) carrying out configuration scanning in which a configuration line of said exploded plane is scanned by said beam irradiation based on a vector-scanning system; and

(b) carrying out field scanning in which a whole surface of said exploded plane is scanned according to a raster-scanning system.

2. The method according to claim 1, wherein said configuration scanning is performed each time a cured resin layer is formed by one or a plurality of field scanings.

3. The method according to claim 1 or 2, wherein said raster-scanning is performed such that the scanning direction thereof is changed on each of a number of exploded planes.

4. The method according to claim 1, 2 or 3, wherein said raster-scanning is performed such that the raster-scanning direction of a preceding field scanning and a raster-scanning direction of the next field scanning are different from each other in scanning direction.

5. The method according to claim 3 or 4, wherein said raster-scanning is performed such that scanning directions thereof on said exploded planes are different from each other by substantially 90 degrees.

6. An apparatus for producing a three-dimensional object in which a beam is irradiated on a liquid surface of a liquid photo-curable resin to form a cured resin layer having a pattern corresponding to a shape of an exploded plane which results from exploding a three-dimensional object image in one direction, a liquid photo-curable resin is placed on said cured resin layer and a beam is again irradiated on a liquid surface of the liquid photo-curable resin layer thereby to sequentially laminate a cured resin layer onto the already-cured

resin layer, so as to form a desired three-dimensional object, said apparatus comprising:

(1) means for performing configuration scanning in which a configuration line of said exploded plane is scanned by said beam irradiation based on a vector-scanning system; and

(2) beam scanning means for performing field scanning in which a whole surface of said exploded plane is scanned according to a raster-scanning system.

7. The apparatus according to claim 6, wherein said scanning means is composed of first deflecting means for deflecting the beam in one straight line direction on said exploded plane and second deflecting means for deflecting the beam in the direction perpendicular to said straight line direction.

8. The apparatus according to claim 7, wherein said scanning means is composed of beam oscillating means and acoustooptic modulating means for turning ON and/or OFF the beam from said beam oscillating means.

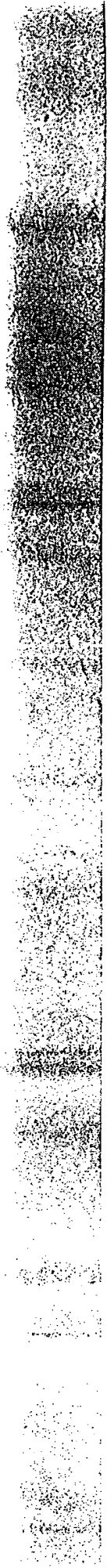
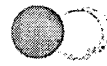


FIG. 1

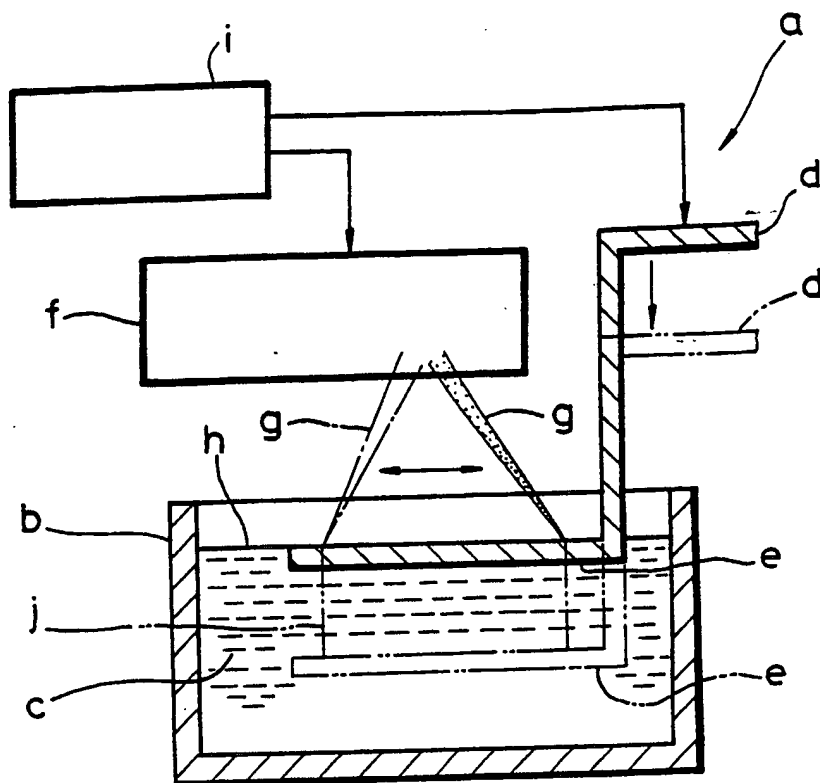


FIG. 2

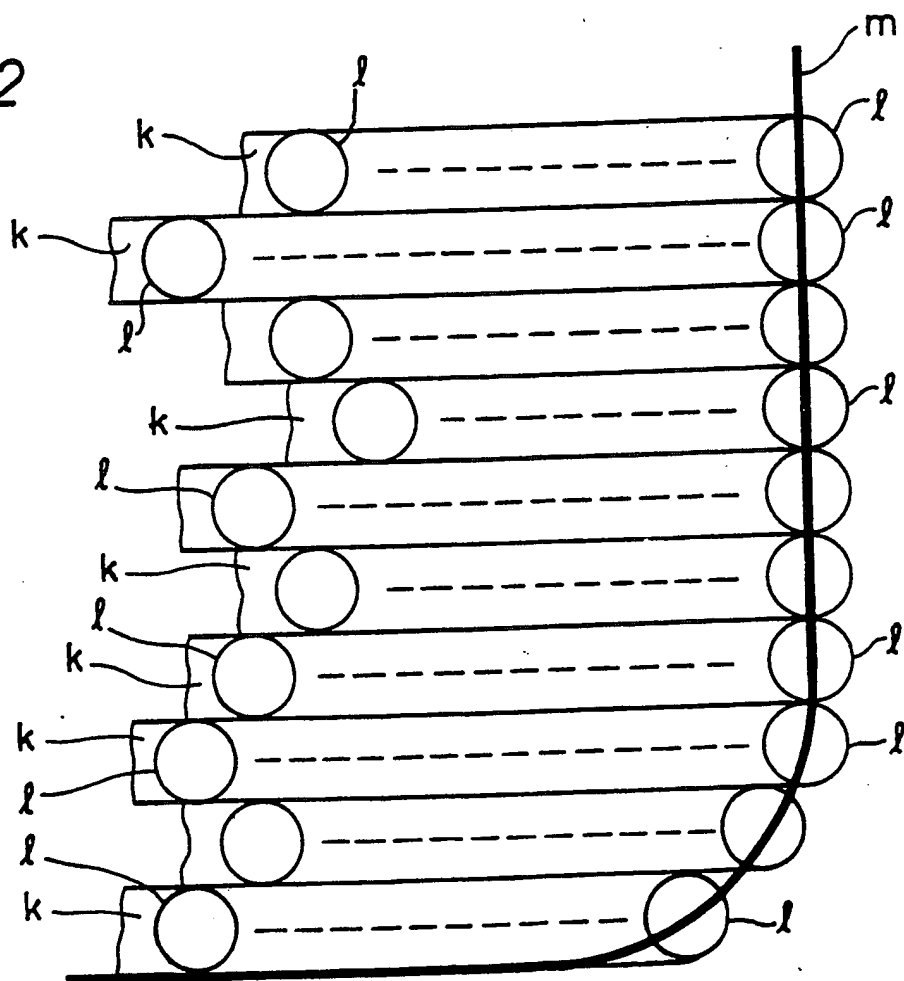


FIG. 3

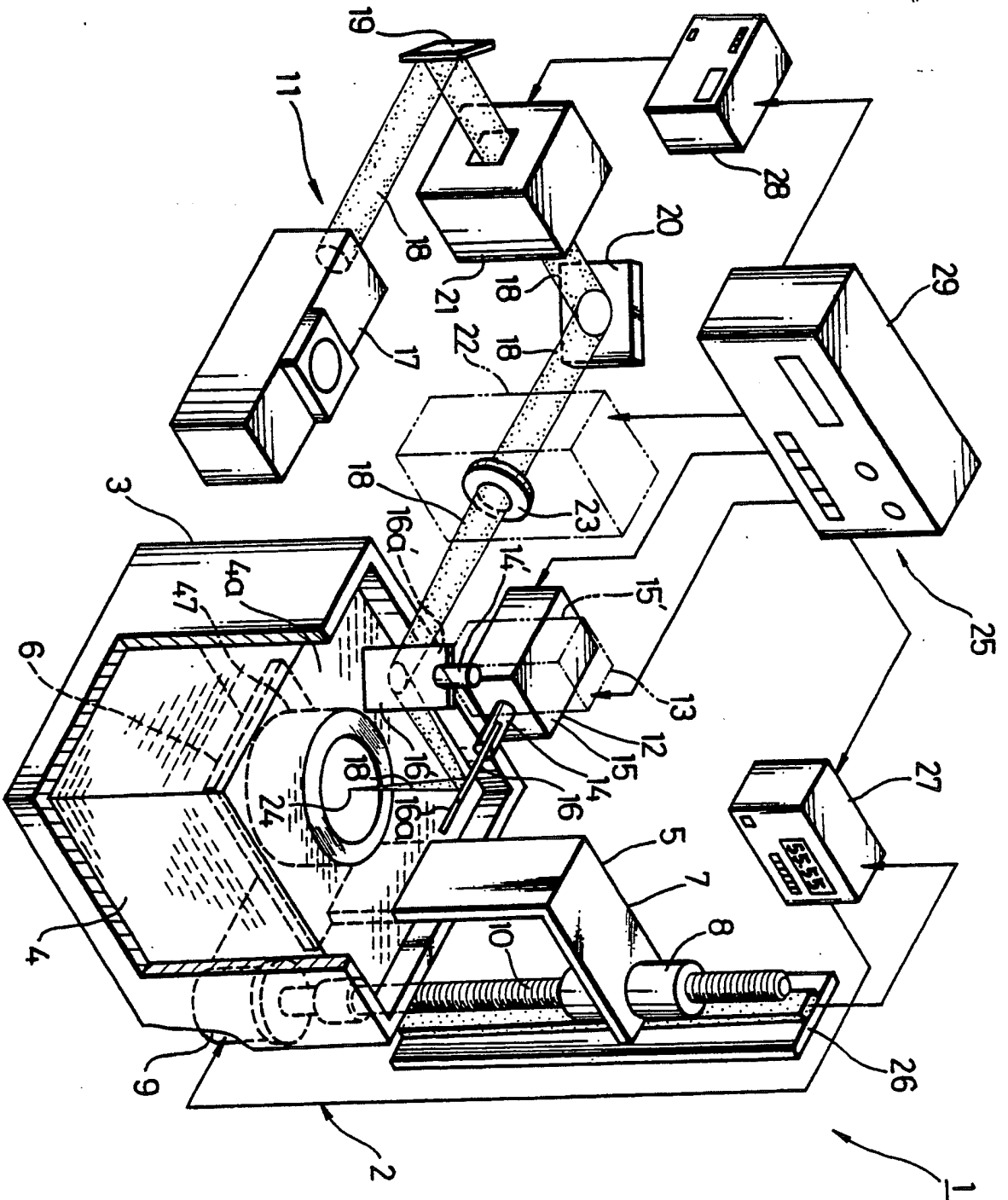


FIG. 4

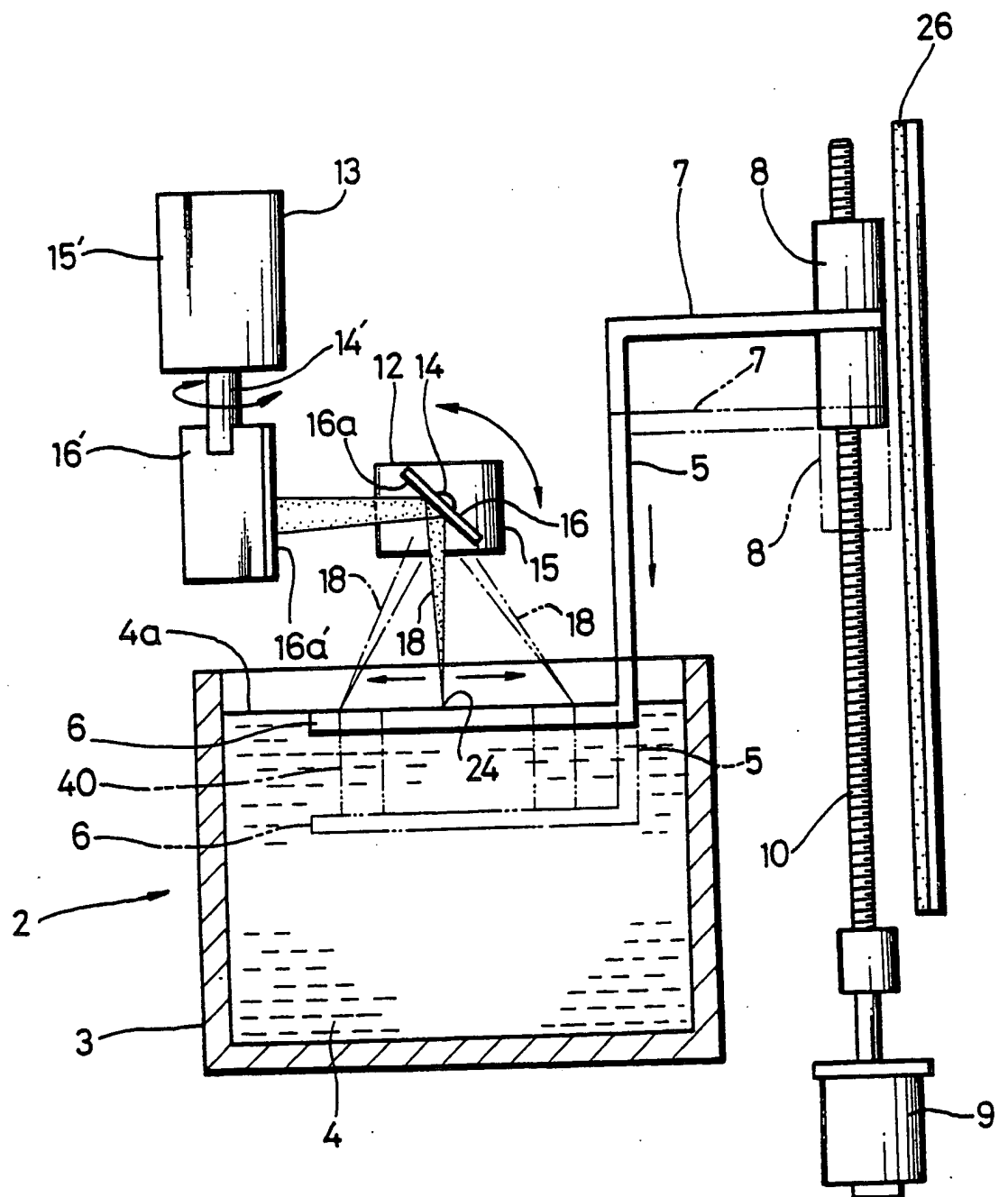


FIG. 5

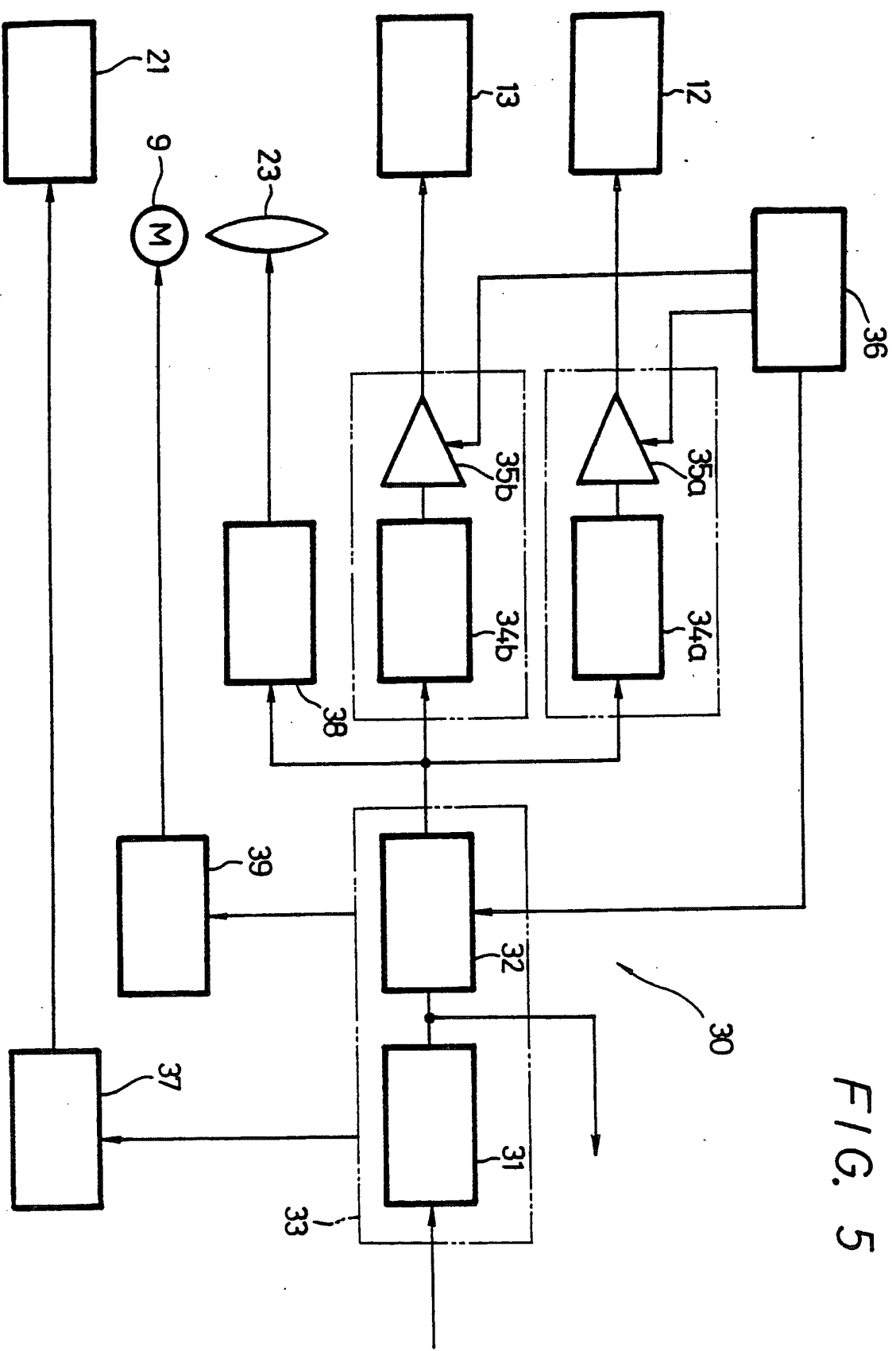


FIG. 6A

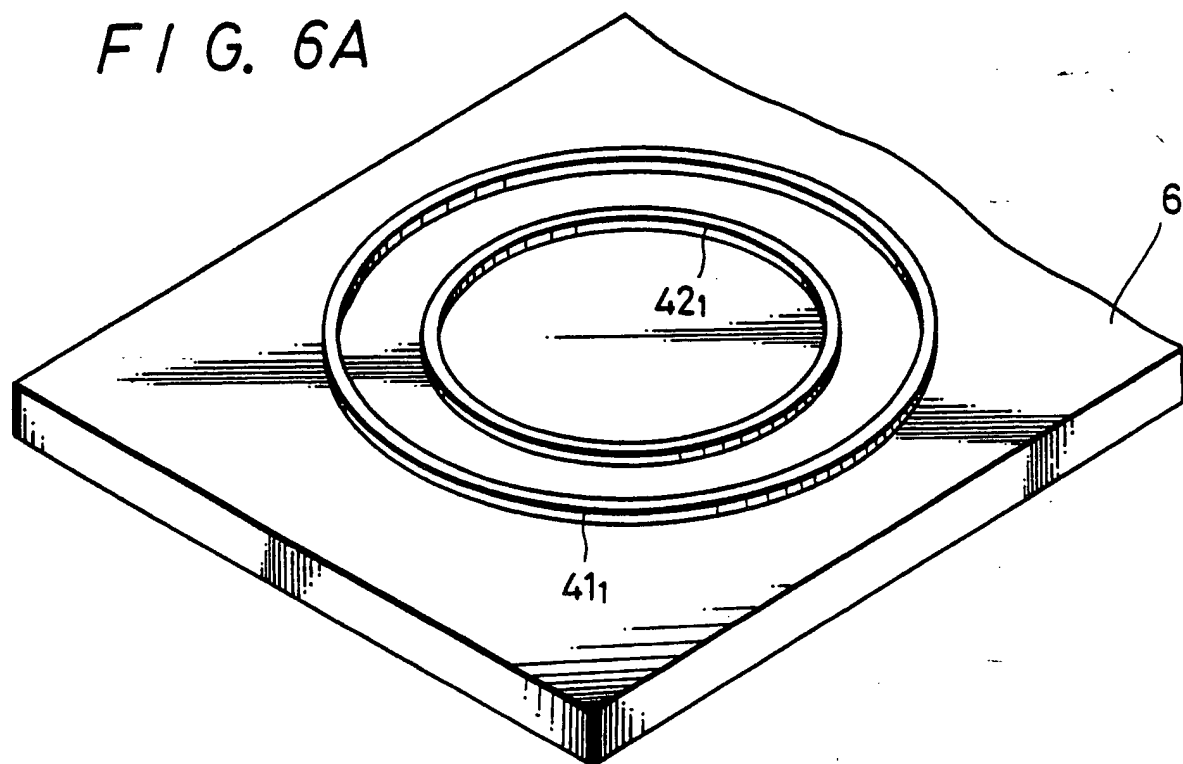


FIG. 6B

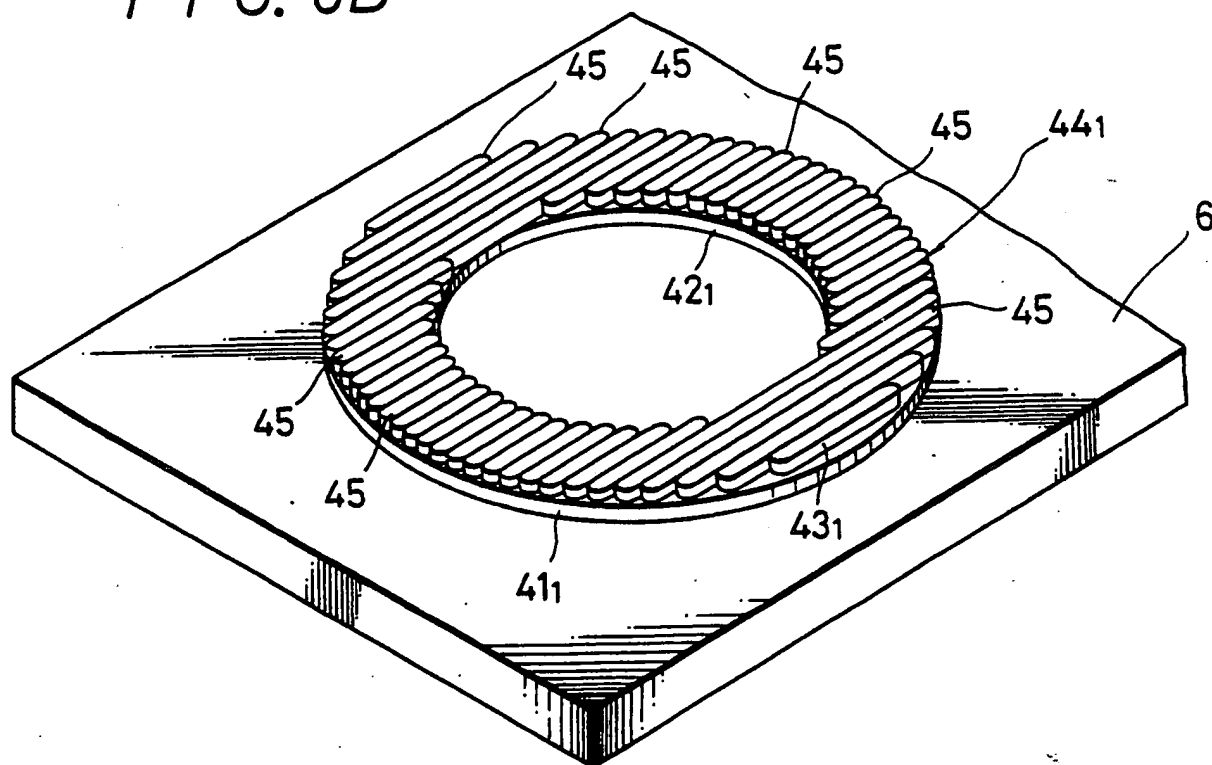


FIG. 6C

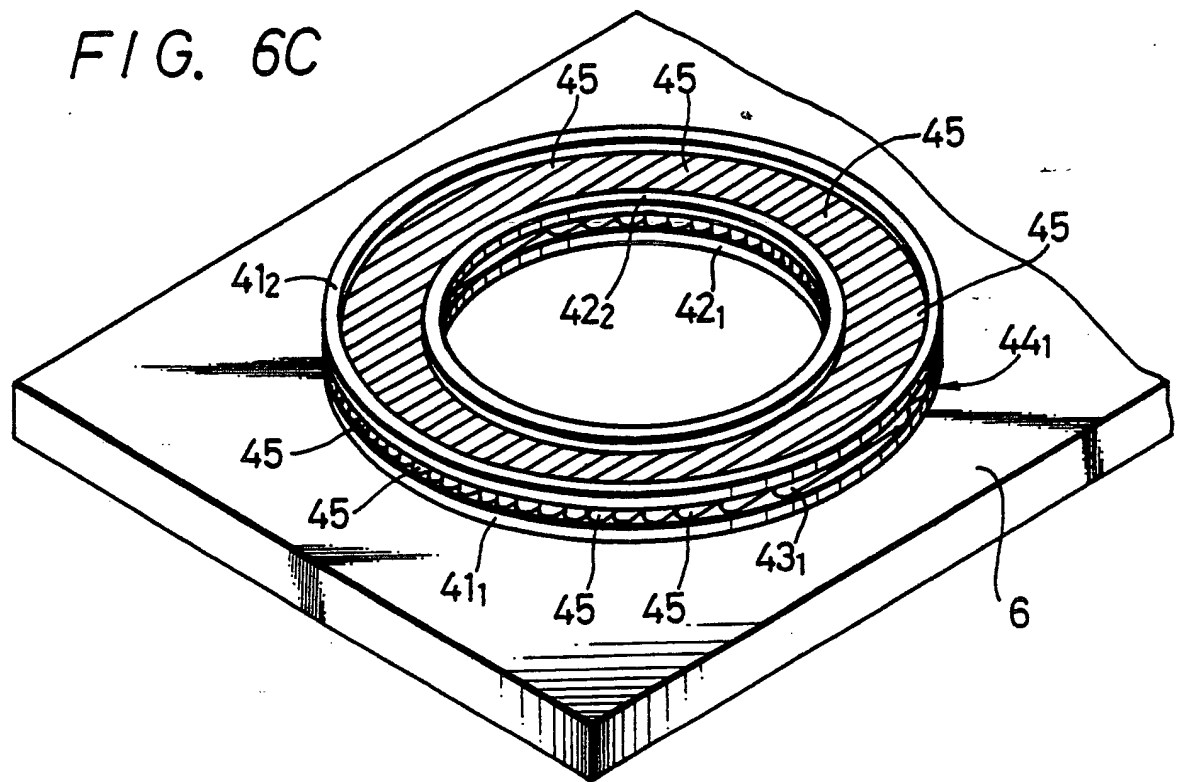


FIG. 6D

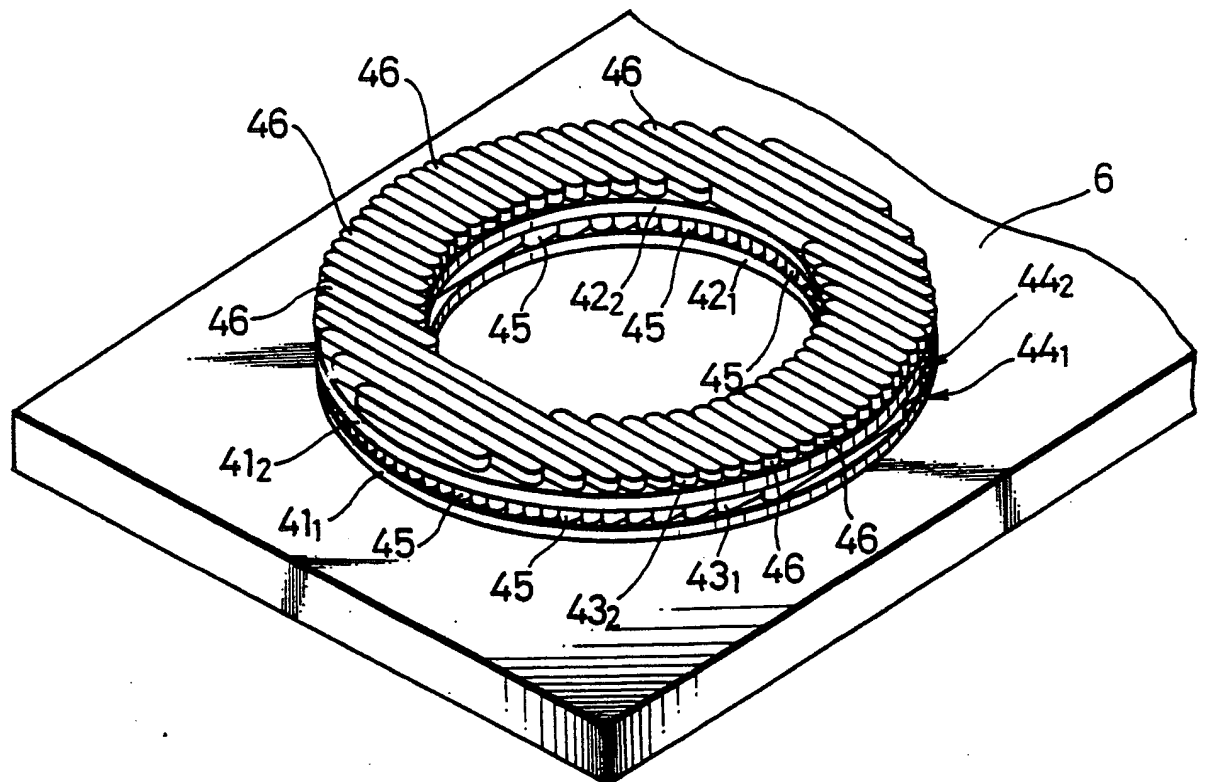


FIG. 7A

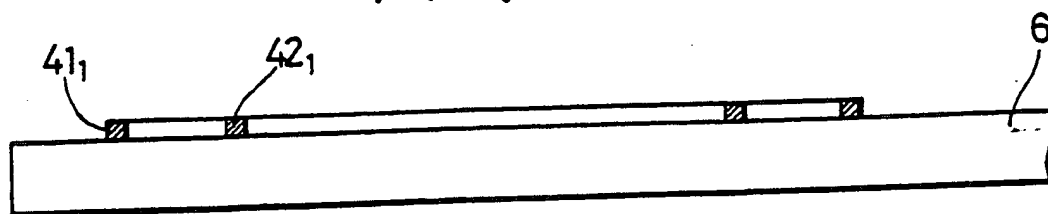


FIG. 7B

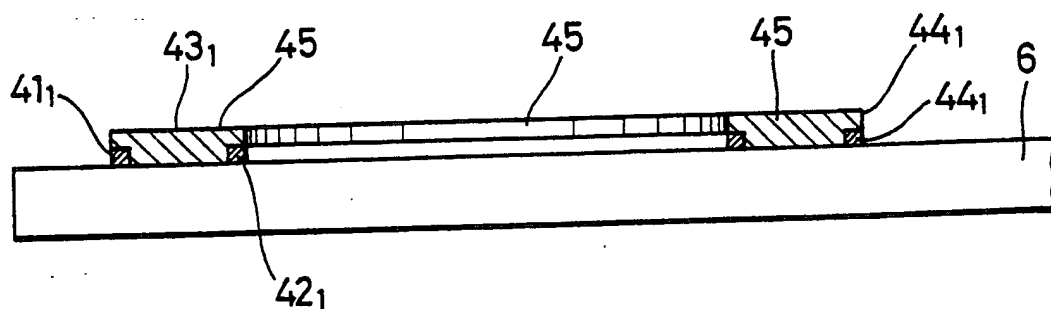


FIG. 7C

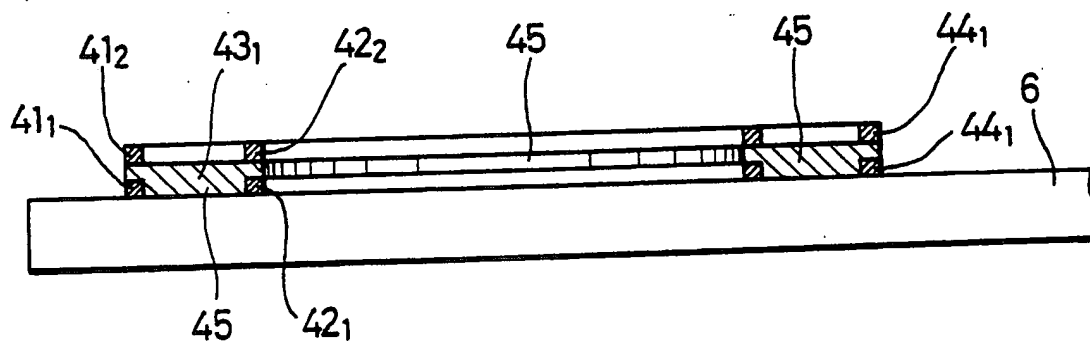


FIG. 7D

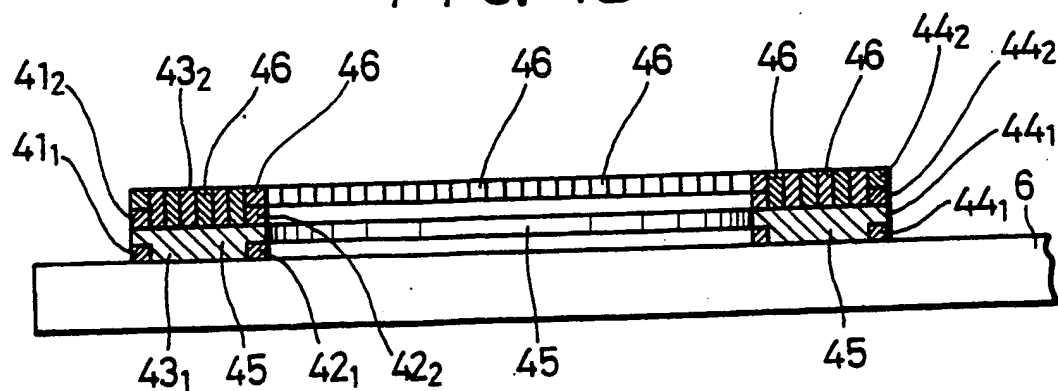


FIG. 8

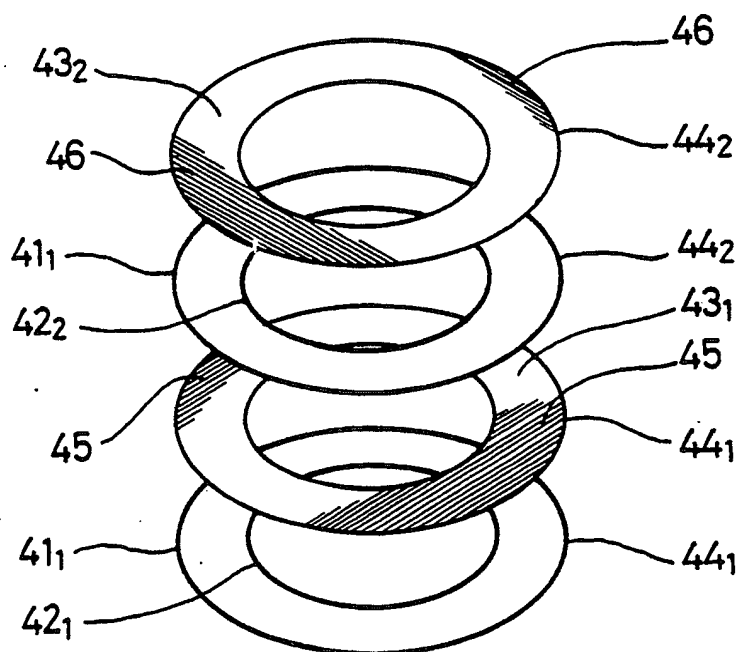
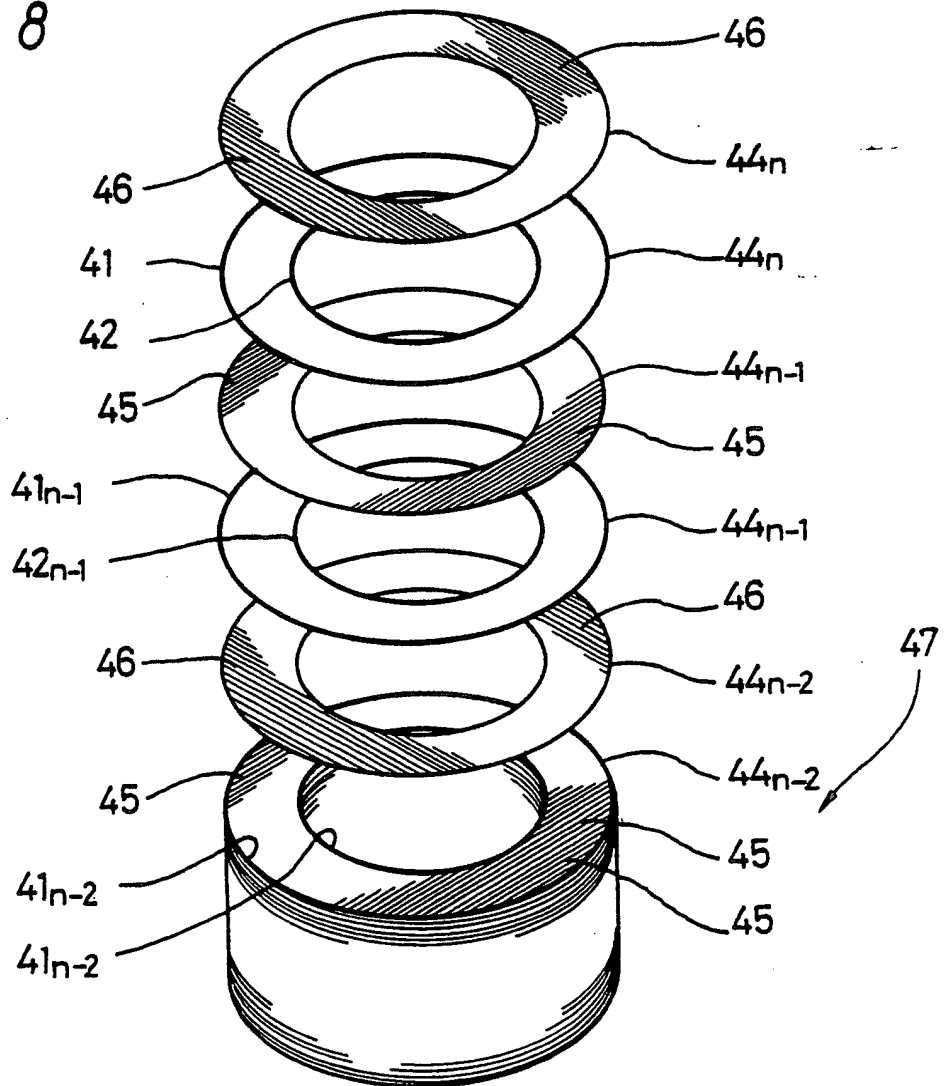
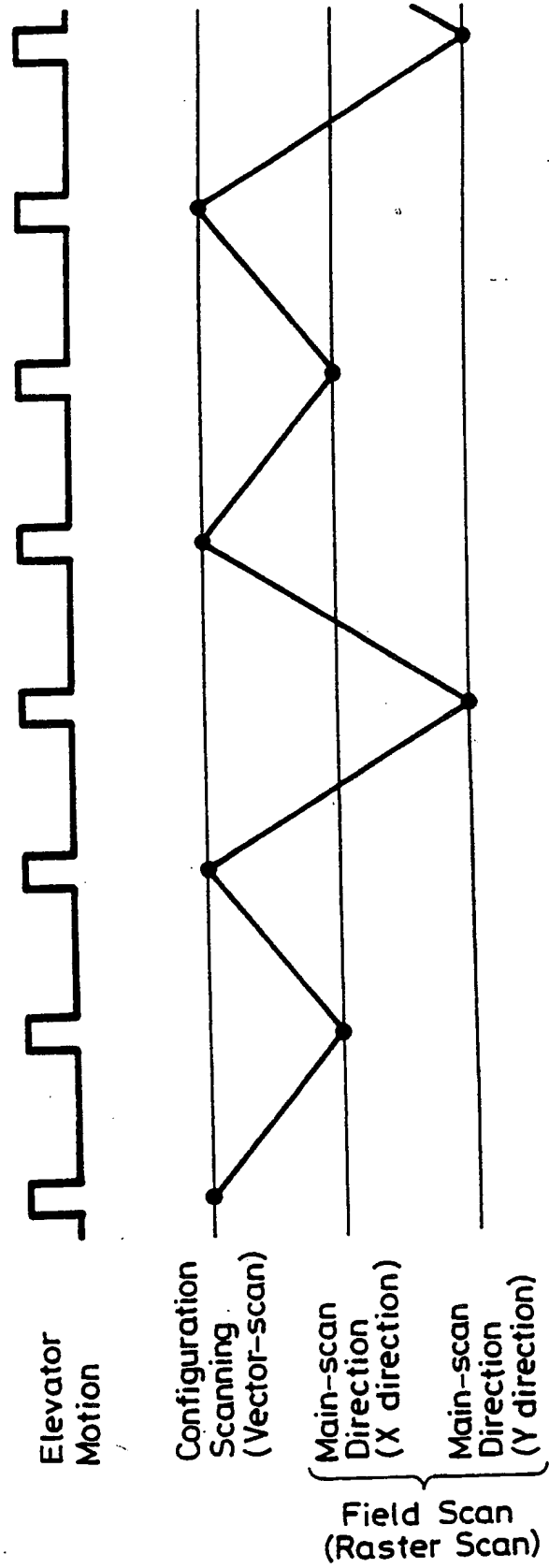
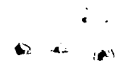
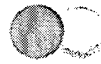


FIG. 9







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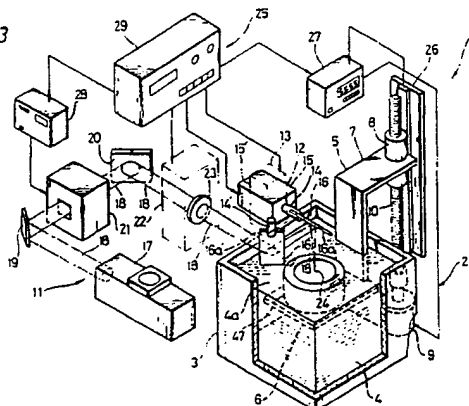
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(54) **Method and apparatus for producing three-dimensional objects.**

(57) A method of and apparatus (1) for producing a three-dimensional object are provided, in which a beam (18) from beam oscillating means (11) is irradiated on a liquid surface of a liquid photo-curable resin (4) to form a cured resin layer having a pattern corresponding to a shape of an exploded plane which results from exploding a desired three-dimensional object image by a certain direction, a liquid photo-curable resin is placed on the cured resin layer and a beam is again irradiated on a liquid

surface of the liquid photo-curable resin layer thereby to sequentially laminated a cured resin layer onto the already-cured resin layer, so as to form a desired three-dimensional object (47). The method and apparatus are characterised by the use of configuration scanning in which a configuration line of the exploded plane is scanned by the beam irradiation based on a vector-scanning system and field scanning in which a whole surface of the exploded plane is scanned according to a raster-scanning system.

FIG. 3



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EUROPEAN SEARCH REPORT

Application Number

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DOCUMENTS CONSIDERED TO BE RELEVANT

Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl.5)
A	US-A-4 575 330 (HULL) * Figure 3; claim 1 *	1-8	B 29 C 39/42 G 03 C 9/08
A	EP-A-0 250 121 (SCITEX CORP. LTD) * Figures 9,10C,16A-16D; column 18, lines 21-26; column 19, lines 21-26; column 24, lines 5-24 *	1-8	
A,D	US-A-4 041 476 (SWAINSON) * Figure 2; claim 1 *	1-8	
			TECHNICAL FIELDS SEARCHED (Int. Cl.5)
			B 29 C B 01 J G 03 C G 09 B
The present search report has been drawn up for all claims			
Place of search		Date of completion of search	Examiner
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